

FORM PTO-1390 (Modified) (REV 10-95)		U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE		ATTORNEY'S DOCKET NUMBER
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371				AD6521
INTERNATIONAL APPLICATION NO. PCT/US98/20499		INTERNATIONAL FILING DATE 30 SEPTEMBER 1998 (30.09.98)		U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR 09 / 486745
TITLE OF INVENTION POLYAMIDE COMPOSITION FOR WELDING				PRIORITY DATE CLAIMED 30 SEPTEMBER 1997 (30.09.97)
APPLICANT(S) FOR DO/EO/US NOZAKI, Masahiro et al.				
Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:				
<ol style="list-style-type: none"> 1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371. 2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371. 3. <input checked="" type="checkbox"/> This is an express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1). 4. <input checked="" type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date. 5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371 (c) (2)) <ol style="list-style-type: none"> a. <input checked="" type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau). b. <input type="checkbox"/> has been transmitted by the International Bureau. c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US). 6. <input type="checkbox"/> A translation of the International Application into English (35 U.S.C. 371(c)(2)). 7. <input checked="" type="checkbox"/> A copy of the International Search Report (PCT/ISA/210). 8. <input checked="" type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3)) <ol style="list-style-type: none"> a. <input type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau). b. <input type="checkbox"/> have been transmitted by the International Bureau. c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired. d. <input checked="" type="checkbox"/> have not been made and will not be made. 9. <input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)). 10. <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)). 11. <input checked="" type="checkbox"/> A copy of the International Preliminary Examination Report (PCT/IPEA/409). 12. <input type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)). 				
Items 13 to 18 below concern document(s) or information included: <ol style="list-style-type: none"> 13. <input type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98. 14. <input checked="" type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included. 15. <input type="checkbox"/> A FIRST preliminary amendment. A SECOND or SUBSEQUENT preliminary amendment. 16. <input type="checkbox"/> A substitute specification. 17. <input checked="" type="checkbox"/> A change of power of attorney and/or address letter. 18. <input checked="" type="checkbox"/> Certificate of Mailing by Express Mail 19. <input type="checkbox"/> Other items or information: 				
17. General Power of Attorney 18. Express Mail Label No. EJ164303038US				

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR	INTERNATIONAL APPLICATION NO.	ATTORNEY'S DOCKET NUMBER																					
09/486745		PCT/US98/20499	AD6521																				
20. The following fees are submitted.:		CALCULATIONS PTO USE ONLY																					
BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)) :																							
<input checked="" type="checkbox"/> Search Report has been prepared by the EPO or JPO \$840.00 <input type="checkbox"/> International preliminary examination fee paid to USPTO (37 CFR 1.482) \$670.00 <input type="checkbox"/> No international preliminary examination fee paid to USPTO (37 CFR 1.482) but international search fee paid to USPTO (37 CFR 1.445(a)(2)) \$760.00 <input type="checkbox"/> Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$970.00 <input type="checkbox"/> International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(2)-(4) \$96.00																							
ENTER APPROPRIATE BASIC FEE AMOUNT =		\$840.00																					
Surcharge of \$130.00 for furnishing the oath or declaration later than months from the earliest claimed priority date (37 CFR 1.492 (e)).		<input type="checkbox"/> 20 <input type="checkbox"/> 30	\$0.00																				
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 25%;">CLAIMS</th> <th style="width: 25%;">NUMBER FILED</th> <th style="width: 25%;">NUMBER EXTRA</th> <th style="width: 25%;">RATE</th> </tr> </thead> <tbody> <tr> <td>Total claims</td> <td>5 - 20 =</td> <td>0</td> <td>x \$18.00</td> </tr> <tr> <td>Independent claims</td> <td>3 - 3 =</td> <td>0</td> <td>x \$78.00</td> </tr> <tr> <td colspan="2">Multiple Dependent Claims (check if applicable).</td> <td style="text-align: center;"><input type="checkbox"/></td> <td style="text-align: center;">\$0.00</td> </tr> <tr> <td colspan="2" style="text-align: center;">TOTAL OF ABOVE CALCULATIONS</td> <td style="text-align: center;">\$840.00</td> <td></td> </tr> </tbody> </table>		CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	Total claims	5 - 20 =	0	x \$18.00	Independent claims	3 - 3 =	0	x \$78.00	Multiple Dependent Claims (check if applicable).		<input type="checkbox"/>	\$0.00	TOTAL OF ABOVE CALCULATIONS		\$840.00			
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Total claims	5 - 20 =	0	x \$18.00																				
Independent claims	3 - 3 =	0	x \$78.00																				
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TOTAL OF ABOVE CALCULATIONS		\$840.00																					
Reduction of 1/2 for filing by small entity, if applicable. Verified Small Entity Statement must also be filed (Note 37 CFR 1.9, 1.27, 1.28) (check if applicable).		<input type="checkbox"/>	\$0.00																				
SUBTOTAL		\$840.00																					
Processing fee of \$130.00 for furnishing the English translation later than months from the earliest claimed priority date (37 CFR 1.492 (f)).		<input type="checkbox"/> 20 <input type="checkbox"/> 30	\$0.00																				
TOTAL NATIONAL FEE		\$840.00																					
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) (check if applicable).		<input checked="" type="checkbox"/>	\$40.00																				
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<p><input type="checkbox"/> A check in the amount of _____ to cover the above fees is enclosed.</p> <p><input checked="" type="checkbox"/> Please charge my Deposit Account No. 04-1928 in the amount of 880. to cover the above fees. A duplicate copy of this sheet is enclosed.</p> <p><input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge any fees which may be required, or credit any overpayment to Deposit Account No. 04-1928 A duplicate copy of this sheet is enclosed.</p>																							
<p>NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.</p>																							
<p>SEND ALL CORRESPONDENCE TO:</p> <p>HAMBY, William H. E.I. DU PONT DE NEMOURS AND COMPANY LEGAL PATENT RECORDS CENTER 1007 MARKET STREET WILMINGTON, DELAWARE 19898 US</p>																							
<p> SIGNATURE Craig H. EVANS Reg. No. 31,825 for HAMBY, William H.</p>																							
<p>NAME 31,521</p>																							
<p>REGISTRATION NUMBER</p>																							
<p>01 March 2000</p>																							
<p>DATE</p>																							

TITLEPolyamide Composition for WeldingField of the Invention

5 The present invention relates to polyamide compositions for welding which are used, for example, in die slide injection molding and in injection molding. This invention relates more particularly to polyamide compositions for welding which contain aromatic polyamides and aliphatic polyamides.

10 Background of the Invention

The molding of hollow molded articles from polymers such as polyamides and polyesters has traditionally relied upon blow molding and injection molding. In cases where thick-walled hollow molded articles and molded articles with a shape having thick-walled sections and thin-walled sections are produced, the 15 molded article to be produced is molded by injection molding a body that has been divided into two sections, arranging the two sections that have been removed from the molds so that they face each other at their parting lines, then heating and welding. Alternatively, the two sections that have been obtained may be placed in another mold so that they face each other at the parting lines, the molten resin 20 injected about the periphery of the opposed faces, and insert molding (or overlap molding) carried out.

JP-B-2-38377 discloses a method for die slide injection molding, which uses a pair of molds comprising one mold provided with a male mold and a female mold for use in molding the two sections of a hollow molded article, and 25 another mold provided with a female mold and a male mold which respectively face the above male die and female die. The sections are both injection-molded at the same time using these molds, after which one of the molds is made to slide so as to cause the sections remaining in the respective female molds to become mutually opposed. By aligning the respective molds in this way, the sections are 30 mutually abutted, then molten resin is injected about the periphery of the abutted faces, thus mutually welding the sections.

Injection welding materials which are known to be used in the production of hollow molded articles and the production of sealed molded articles include compositions including copolymers of a polyamide 6 component with a 35 polyamide 66 component, and an inorganic filler (JP-B 8-337718); compositions including resin mixtures of a polyamide 6/66 copolymer with polyamide 12, and an inorganic filler (JP-A 9-57789); and resin mixtures of polyamide 66, polyamide 12 and polyamide 6/66 copolymer, and an inorganic filler (JP-A 9-57790).

MI 13-09-93

Several other references pertain to the general field of the invention, see generally EP-A-0 104 436, 4 April 1984; EP-A-0 580 387, Mitsubishi Gas Chemical Company, 26 January 1994; EP-A-0 458 470, 27 November 1991; EP-A-0 488 335, 3 June 1992; EP-A-0 532 963, 24 March 1993; Macromolecules, vo.29, no.5, 26 February 1996, pages 1836 - 1838, XP000555560; and Journal of Applied Polymer Science, vol.43, 1991, pages 259-269, XP002089900. However, these references do not disclose the particular blends of the instant invention and their cited benefits.

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However, it will be appreciated by those skilled in the art that these materials are insufficient both with respect to weldability and heat resistance.

The object of the present invention is to provide a polyamide composition for welding which has excellent weldability, heat resistance and hydrolysis resistance. More specifically, the object of this invention is to provide polyamide compositions for molding which are highly suitable for such purposes as die sliding injection molding to produce hollow molded articles such as air intake manifolds, and injection molding to produce sealed molded components, in which an internal component has been protected from external influences, such as 10 solenoids, aspirated air temperature sensors, and wheel speed sensors.

Summary of the Invention

There is disclosed and claimed herein polyamide compositions for welding comprising

15 (A) an aromatic polyamide having a molar fraction of aromatic monomers among monomer components of said polyamide of at least 0.2, and
(B) an aliphatic polyamide,

wherein the weight ratio of (A) and (B) is from 99:1 to 5:95.

20 Another embodiment of the present invention is a polyamide composition comprising aromatic polyamide (A) having a carboxylic acid component of terephthalic acid or a mixture of terephthalic acid and isophthalic acid and optionally aliphatic acid, and a diamine component of hexamethylenediamine or a mixture of hexamethylenediamine and 2-methyl pentamethylenediamine, and an 25 aliphatic polyamide (B), wherein the weight ratio of (A) and (B) is from 99:1 to 5:95.

Yet another embodiment of the present invention is a polyamide molded article comprised of two or more members, wherein at least two of the members have been welded using the above-described polyamide composition for welding.

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Brief Description of the Drawing

Figure 1 is a test piece for evaluating weldability.

Detailed Description of the Invention

35 The polyamide compositions of the present invention are welding compositions, and may be employed in any known welding techniques such as injection welding, vibration welding, ultrasonic welding, and spin welding.

The polyamide (A) useful in this invention is an aromatic polyamide in which the molar fraction of the aromatic monomer within the monomer components making up the polyamide is at least 0.2. In other words, this is a polyamide in which one or more of the diamine, dicarboxylic acid, and/or 5 aminocarboxylic acid monomer components making up the polyamide is an aromatic compound, and which is composed of monomers wherein the molar fraction of aromatic monomers, based on all of the monomers, is at least 0.2.

If the molar fraction of the aromatic monomers is less than 0.2, a high heat resistance, and an excellent hydrolysis resistance and chemical resistance cannot 10 be achieved. Moreover, properties such as these are not exhibited even in compositions. The molar fraction of the aromatic monomer is preferably from 0.25 to 0.5, and more preferably from 0.4 to 0.5.

Examples of aromatic monomers that may serve as components in the aromatic polyamide include aromatic diamines, such as p-phenylenediamine, o- 15 phenylenediamine, m-phenylenediamine, p-xylenediamine and m-xylenediamine; aromatic dicarboxylic acids, such as terephthalic acid, isophthalic acid, phthalic acid, 2-methylterephthalic acid, and naphthalenedicarboxylic acid; and aromatic aminocarboxylic acids, such as p-aminobenzoic acid. These aromatic monomers may be used singly or as combinations of two or more thereof.

20 Monomers other than aromatic monomers which may be present in the aromatic polyamide include aliphatic dicarboxylic acids, aliphatic alkylenediamines, alicyclic alkylenediamines, and aliphatic aminocarboxylic acids. Exemplary aliphatic dicarboxylic acids include adipic acid, sebacic acid, azelaic acid and dodecanedioic acid; these may be used singly or in combinations 25 of two or more thereof. Exemplary aliphatic alkylenediamine, which may be straight-chain or branched, include ethylenediamine, trimethylenediamine, tetramethylenediamine, pentamethylenediamine, hexamethylenediamine, 1,7-diaminoheptane, 1,8-diaminoctane, 1,9-diaminononane, 1,10-diaminodecane, 2-methyl pentamethylenediamine and 2-ethyl tetramethylenediamine. These 30 aliphatic alkylenediamines may be used singly or as combinations of two or more thereof. Exemplary alicyclic alkylenediamines include 1,3-diaminocyclohexane, 1,4-diaminocyclohexane, 1,3-bis(aminomethyl)cyclohexane, bis(aminomethyl)cyclohexane, bis(4-aminocyclohexyl)methane, 4,4'-diamino-3,3'-dimethyldicyclohexylmethane, isophoronediamine and piperazine. These 35 alicyclic alkylenediamines may be used singly or as combinations of two or more thereof. Exemplary aminocarboxylic acids include ϵ -aminocaproic acid and ω -aminoundecanoic acid, and may be used singly or as combinations of two or more thereof.

Preferable examples of the polyamide (A) include those in which the carboxylic acid component is terephthalic acid or a mixture of terephthalic acid with isophthalic acid and optionally aliphatic acid, and the diamine component is hexamethylenediamine or a mixture of hexamethylenediamine with 2-methylpentamethylenediamine.

5 Aliphatic polyamides (B) useful in the present invention include polyamide 66, polyamide 6, polyamide 610, polyamide 612, polyamide 46, polyamide 11, and polyamide 12, and polyamide 66 is especially preferred.

10 The above-described polyamides (A) and (B) are used in a weight ratio of 99:1 to 5:95, preferably 97:3 to 50:50, and more preferably 95:5 to 80:20. At an aromatic polyamide blending ratio higher than 99 or less than 5, the weldability is poor.

15 The polyamide composition of the present invention comprising (A) an aromatic polyamide comprising carboxylic acid component comprising aliphatic dicarboxylic acid and diamine component comprising aromatic diamine or a mixture of aromatic and aliphatic diamine, and (B) aliphatic polyamide should comprise at least 50% by weight of (A) aromatic polyamide based on a total weight of (A) and (B) polyamides. The above described polyamide (A) and (B) are used in a weight ratio of 50:50 to 95:5. If (A) polyamide is less than 50 wt. %, 20 tensile shear strength is low and such polyamide composition cannot be used to weld polyamide molded articles composed of two or more members.

25 The compositions of the invention may also contain inorganic fillers in order to increase the mechanical properties. Exemplary inorganic fillers include glass fibers, carbon fibers, potassium titanate whiskers, kaolin, talc and mica, with the use of glass fibers being preferred. The amount of inorganic filler blended into the composition, based on the weight of the composition, is generally from 5 to 60% by weight, preferably from 7.5 to 50% by weight, and more preferably from 10 to 45% by weight. At less than 5% by weight, the increase in mechanical strength is insufficient, whereas blending in a large amount of more than 60% by 30 weight results in a poor moldability.

35 In addition to the above-mentioned components, additives such as flame retardants, impact modifiers, heat stabilizers, plasticizers, antioxidants, nucleating agents, dyes, pigments, and parting agents may also be compounded in the inventive compositions within a range that does not compromise the properties thereof.

The polyamide compositions for welding of the present invention may be produced by a number of conventional methods as will be appreciated by those skilled in the art. Examples of such methods include a method in which two

polyamides are mixed, then are kneaded and extruded using a twin-screw extruder or some other melt-kneading apparatus, and pelletized; a method wherein two low-molecular-weight aromatic polyamides are mixed and polymerized, or a method in which extrusion polymerization is carried out concurrent with mixing.

5 It is also possible to carry out melt kneading and molding together using an injection molding machine.

The polyamide composition for welding of this invention is used to weld polyamide molded articles composed of two or more members. The members may each be made of a composition containing the same polyamide mixture as the 10 polyamide mixture within the polyamide composition for welding that is used, they may be made of a composition containing a mixture of the same types of polyamides but in a different blending ratio, or they may be made of a composition containing a mixture of different polyamides.

15 Examples

Examples 1-2 and Comparative Examples 1-4

The polyamide shown in Table 1 and glass fibers (chopped strands, from Nippon Sheet Glass Co., Ltd.) were melt-kneaded in a twin-screw extruder (ZSK-40, from W&P), water-cooled, then pelletized. Using the resulting pellets, the 20 primary molded article shown in Fig. 1 was injection molded. This primary molded article 1 was then set in a mold and, using the same pellets, a test piece 2 (18x100x3mm; overlapping portion 3, 18x20mm) was molded by overlap molding (secondary molding). The mold temperature and resin temperature during molding are shown in Table 1.

25 The tensile shear strength was measured using the test pieces 2 thus obtained. Measurement was carried out in accordance with ASTM D638, at room temperature, and at a test speed of 5 mm/min. The measurement results are shown in Table 2.

The heat resistance was also determined, measurement being carried out in 30 accordance with ASTM D648. The heat distortion temperature (HDT) was measured at 18.6 kg/cm². The measurement results are shown in Table 2.

In addition, the hydrolysis resistance was tested. The test piece 2 was 35 immersed 48 hours in a 50% aqueous solution of ethylene glycol at 150°C, following which the tensile strength was measured. The tensile strength value measured after 250 hours of immersion was computed as a percentage of the original measured value, and this percentage was regarded as the tensile strength retention. The results are shown in Table 2.

The polyamides in the tables were as follows.

Polymer A: A polyamide in which the dicarboxylic acid component is terephthalic acid and the diamine components are hexamethylenediamine (HMD) and 2-methyl pentamethylenediamine (MPMD) (HMD:MPMD = 5 50:50)

Polymer B: Polyamide 6

Polymer C: Polyamide 66

Polymer D: Polyamide 612

Polymer E: Polyamide 6T66 (6T:66=55:45)

10 Polymer F: Polyamide MXD6 (m-xylylenediamine-6)

Table 1

	Ex. 1	Ex. 2	Comp. Ex. 1	Comp. Ex. 2	Comp. Ex. 3	Comp. Ex. 4
Mold temperature in primary molding (°C)	120	120	120	120	120	120
Resin temperature in primary molding (°C)	310	340	290	310	290	340
Pre-heating temperature (°C)	120	120	120	120	120	120
Mold temperature in secondary molding (°C)	120	120	80	80	80	120
Resin temperature in secondary molding (°C)	310	340	290	290	290	340

Table 2

	Ex. 1	Ex. 2	Comp. Ex. 1	Comp. Ex. 2	Comp. Ex. 3	Comp. Ex. 4
Polymer A (wt %)	52.0	58.5	0	0	0	65.0
Polymer B (wt %)	0	0	70.0	0	0	0
Polymer C (wt %)	13.0	6.5	0	70.0	33.5	0
Polymer D (wt %)	0	0	0	0	33.5	0
Glass fibers (wt %)	35.0	35.0	30.0	30.0	33.0	35.0
Tensile shear strength (kg/cm ²)	232.3	200.0	217.8	84.3	102.3	88.7
Heat distortion temperature (°C)	255	260	215	254	215	260
Tensile strength retention (%)	76.6	81.0	<50	73.5	68.6	87.2

TABLE 3

	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7	Ex. 8
Mold temperature in primary molding (°C)	120	120	120	120	120	120
Resin temperature in primary molding (°C)	340	340	340	340	340	340
Pre-heating temperature (°C)	120	120	120	120	120	120
Mold temperature in secondary molding (°C)	120	120	120	120	120	120
Resin temperature in secondary molding (°C)	340	340	340	340	340	340

TABLE 4

	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7	Ex. 8
Polymer A (wt %)	61.75	32.5	13.0	6.50	0	0
Polymer B (wt %)	0	0	0	0	0	0
Polymer C (wt %)	3.25	32.5	52.0	58.50	80.0	20.0
Polymer D (wt %)	0	0	0	0	0	0
Polymer E (wt %)	0	0	0	0	20.0	0
Polymer F (wt %)	0	0	0	0	0	80.0
Glass fibers (wt %)	35.0	35.0	35.0	35.0	35.0	35.0
Tensile shear strength (kg/cm ²)	197.2	212.4	190.8	205.2	205.2	194.4
Heat distortion temperature (°C)	263	240	250	253	254	230
Tensile strength retention (%)	84.0	67.0	67.1	70.5	70.0	65.0

5 Upon comparing Examples 1 and 2 with Comparative Example 1, it is apparent that although polyamide 6 has good weldability, the heat resistance and hydrolysis resistance are insufficient.

Examples 3-8

10 The polyamides of Examples 3-8 and described in Tables 3 and 4 were prepared and tested in the same manner as described above.

WHAT IS CLAIMED IS:

1. A polyamide composition for welding comprising
 - (A) an aromatic polyamide having a molar fraction of aromatic monomers among monomer components of said polyamide of at least 0.2, and
 - (B) an aliphatic polyamide,
wherein the weight ratio of (A) and (B) is from 99:1 to 20:80.
2. A polyamide composition for welding comprising
 - (A) an aromatic polyamide having a carboxylic acid component consisting of terephthalic acid, isophthalic acid or a mixture of terephthalic acid and isophthalic acid and optionally aliphatic acid; and a diamine component of aliphatic diamine, and,
 - (B) aliphatic polyamide,
wherein the weight ratio of (A) and (B) is from 99:1 to 5:95.
3. A polyamide molded article comprised of two or more members, wherein at least two of the members have been welded using the polyamide composition for welding of Claim 1.
4. The composition of claim 2 wherein said aromatic polyamide comprising the carboxylic acid component being terephthalic acid or a mixture of terephthalic acid and isophthalic acid; and the diamine component being hexamethylenediamine or a mixture of hexamethylenediamine and 2-methyl pentamethylenediamine.
5. A polyamide composition for welding comprising
 - (A) an aromatic polyamide wherein the carboxylic acid component is aliphatic dicarboxylic acid; and the diamine component is aromatic diamine or a mixture of aromatic and aliphatic diamines, and
 - (B) aliphatic polyamide,
wherein the weight ratio of (A) and (B) is from 50:50 to 95:5.

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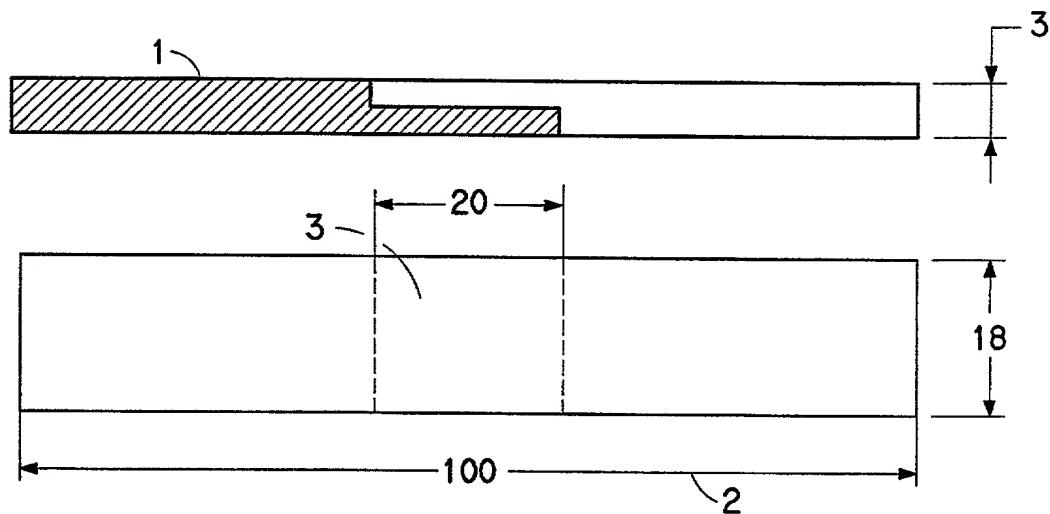


FIG. 1

GENERAL POWER OF ATTORNEY

(Concerning Several International Patent Applications)

The undersigned, Vernon R. Rice, Vice President and Assistant General Counsel of E. I. DU PONT DE NEMOURS AND COMPANY, 1007 Market Street, Wilmington, Delaware 19898 USA ("DuPont"), hereby confirms that the power to sign for DuPont has been granted to various individuals (as set forth in the attached excerpt from DuPont's Patent Board Rules of Procedure (January 1988), Appendix Section III.A.4), including the Chairman, Vice-Chairman, and those individuals who are Assistant Secretaries of the Patent Board. Currently these Assistant Secretaries are:

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In addition, the authority to act on behalf of DuPont before the competent International Authorities in connection with any and all international patent applications filed by it with the United States as Receiving Office and to make or receive payments on its behalf is hereby granted to:

54

Beardell, Lori Y.	<u>34,293</u>	Young, J. Kenneth	<u>41,881</u>
Belopolsky, Inna	<u>43,319</u>	Katz, Elliott A.	<u>26,396</u>
Benjamin, Steven C.	<u>36,087</u>	Kelly, Patricia L.	<u>39,247</u>
Birch, Linda D.	<u>38,719</u>	King, Karen K.	<u>34,850</u>
Bowen, Jr., Alanson G.	<u>24,027</u>	Krukiel, Charles E.	<u>27,344</u>
Christenbury, Lynne M.	<u>30,971</u>	Jarnholm, Arne R.	<u>30,396</u>
Cotreau, William J.	<u>36,490</u>	Lerman, Bart E.	<u>31,897</u>
Deitch, Gerald E.	<u>30,457</u>	Levitt, Cary A.	<u>31,848</u>
Deshmukh, Sudhir	<u>33,677</u>	Magee, Thomas H.	<u>27,355</u>
Dobson, Kevin S.	<u>40,296</u>	Mayer, Nancy S.	<u>29,190</u>
Duffy, Roseanne R.	<u>33,869</u>	Medwick, George M.	<u>27,456</u>
Edwards, Mark A.	<u>39,542</u>	Morrissey, Bruce W.	<u>30,663</u>
Estrin, Barry	<u>26,452</u>	Santopietro, Lois A.	<u>36,264</u>
Evans, Craig H.	<u>31,825</u>	Schaeffer, Andrew L.	<u>33,605</u>
Fair, Tamera L.	<u>35,867</u>	Sebree, Chyrea J.	<u>45,348</u>
Feltham, S. Neil	<u>36,506</u>	Shafer, Robert J.	<u>24,437</u>
Floyd, Linda Axamethy	<u>33,692</u>	Shay, Lucas K.	<u>34,724</u>
Frank, George A.	<u>27,636</u>	Shipley, James E.	<u>32,003</u>
Golian, Andrew G.	<u>25,293</u>	Siegell, Barbara C.	<u>30,684</u>
Gorman, Thomas W.	<u>31,959</u>	Sinnott, Jessica M.	<u>34,015</u>
Gould, David J.	<u>25,338</u>	Steinberg, Thomas W.	<u>37,013</u>
Griffiths, John E.	<u>32,647</u>	Stevenson, Robert B.	<u>26,039</u>
Hamby, Jane O.	<u>32,872</u>	Strickland, Frederick D.	<u>39,041</u>
Hamby, William H.	<u>31,521</u>	Tessari, Joseph A.	<u>32,177</u>
Heiser, David E.	<u>31,366</u>	Tulloch, Rebecca W.	<u>36,297</u>
Hendrickson, John S.	<u>30,847</u>	Walker, P. Michael	<u>32,602</u>
Jones, Brian C.	<u>37,857</u>	Wang, Chen	<u>38,650</u>

The undersigned ratifies fully all actions already taken by the above-named individuals in accordance with the authority granted hereby.

E. I. DU PONT DE NEMOURS AND COMPANY

By: Vernon R. Rice

Vernon R. Rice
Vice President and Assistant General Counsel

Date: 2/17/2000

DECLARATION and POWER OF ATTORNEY

As a below-named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

Polyamide Composition For Welding

the specification of which is attached hereto unless the following box is checked:

■ was filed on 30 September 1998 as U.S. Application No. _____ or PCT International Application No. PCT/US98/20499 and was amended on _____ (if applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is known to me to be material to patentability as defined in 37 CFR § 1.56.

I hereby claim foreign priority benefits under 35 U.S.C. § 119(a)-(d) or § 365(b) of any foreign application(s) for patent or inventor's certificate, or § 365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate, or PCT International application having a filing date before that of the application on which priority is claimed.

Application No.	Country	Filing Date	Priority Claimed (Yes/No)
9 (97) 281114	Japan	30 September 1997	Yes

I hereby claim the benefit under 35 U.S.C. § 119(e) of any United States Provisional Application(s) listed below.

U.S. Provisional Application No.	U.S. Filing Date

I hereby claim the benefit under 35 U.S.C. § 120 of any United States application(s), or § 365(c) of any PCT International Application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application or PCT International Application in the manner provided by the first paragraph of 35 U.S.C. § 112, I acknowledge the duty to disclose information which is known to me to be material to patentability as defined in 37 CFR § 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

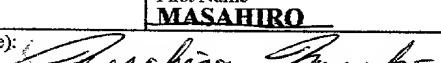
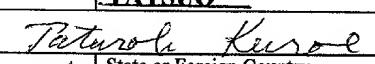
Application No.	Filing Date	Status (patented, pending or abandoned)

POWER OF ATTORNEY: I hereby appoint the following attorney(s) and/or agent(s) the power to prosecute this application and transact all business in the Patent and Trademark Office connected therewith:

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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

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Additional Inventors are being named on separately numbered sheets attached hereto.